

IN THE ABSTRACT OF THE DISCLOSURE:

A nonaqueous electrolyte secondary cell ~~comprises~~ includes a rolled-up electrode unit composed of a positive electrode, a negative electrode and a separator interposed therebetween, and a negative electrode current collector plate and a positive electrode current collector plate joined to the respective ends of the electrode unit. ~~The negative electrode collector plate is joined to an edge of the negative electrode projecting at one of the opposite ends of the electrode unit.~~ The collector plate has a two-layer structure comprising a copper layer made of copper or an alloy consisting predominantly of copper, and a metal layer made of a metal not forming an intermetallic compound with lithium and having a lower laser beam reflectivity than copper or an alloy consisting predominantly of the metal. The collector plate has its copper layer contacted with ~~the edge of the negative electrode~~ an edge of the negative electrode projecting at one of the opposite ends of the electrode unit and welded thereto with a laser beam.